

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016914**Date Inspected:** 14-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (A, B, C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion corner joint between Side plate to Edge Plate of segment 11DW. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area.

The Weld Designation is as follows

SEG071A-040,041

Ultrasonic Testing (UT) for Segment 11DW

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 11DW weld joints.

The welds designation reviewed are as follows:

WELDING INSPECTION REPORT

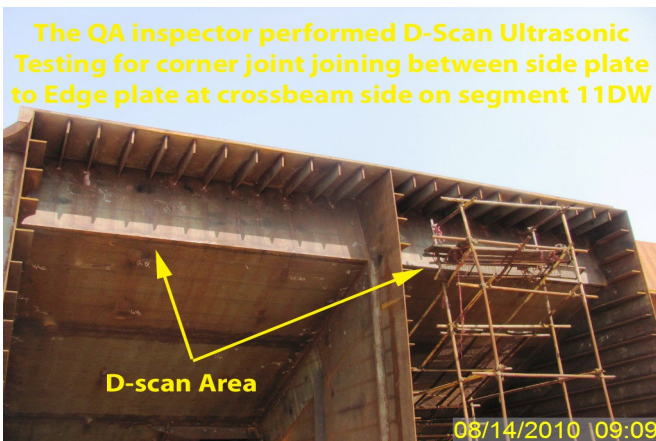
(Continued Page 2 of 3)

SEG071A-010,012,015,014,034,035,040
SEG071C-001,002,003,024,025,033,052,053,054
SSD11A-PP105-010,013,088,217,185
SSD12A-PP106-011,014,091,184
SEG071D-013,040,049

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 11DW, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal linear indication measuring approximately 15mm in length. The indication dbS rating is a +9. Material thickness is 16mm. The depth of the indication is approximately 10mm. The weld is identified as SEG071A-013 at crossbeam Side. The weld is Complete Joint Penetration (CJP) butt joint. The joint joining between side plate SP745A to Side Plate SP507A. The weld is designated as Seismic Performance Critical Material (SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 2250 mm from PP105. Segment 11DW is located at near trial assembly Yard. The Notice of Witness Inspection (NWIT) No. is 006397. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA Inspector did not generate any incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera, Subhasis

Quality Assurance Inspector

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Reviewed By: Patterson,Rodney

QA Reviewer